

Date: Monday, 20/04/2009 12:59:59 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE SPACER
Job Number :	47292		
Estimate Number :	10827		
P.O. Number :		Part Number :	D2877
This Issue :	20/04/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2877 REV B
First Issue :	1 / 1	Project Number :	N/A
Previous Run :	46518	Drawing Revision :	B
Written By :		Material :	
Checked & Approved By :	<u>JLD 09.04.20</u>	Due Date :	10/05/2009
Comment :	Est B 00.05.19 Added inspect level 8 EC Est C 06.04.26 Water jet EC Est Rev:D Now M6061-T6 06-06-23 JLM Est Rev:E Updated Thickness as per Rev B 06-09-18 JLM		

Qty: 120 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S125	6061-T6 .125 Sheet
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Comment: Qty.: 0.0637 sf(s)/Unit Total: 7.6482 sf(s)
 Material: 6061-T6 (QQ-A-250/8) 0.125" Thick
 Batch: 110062 1B 9-5-6

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2877
 Dwg Rev: B
 Prog Rev: B

1B 9-5-6

(120)

2- deburr

1B 9-5-6

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1B 9-5-6

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

8 09/05/08

counter

(120)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

M. L

09/05/11

(120X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SADDLE SPACER

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Cmp/BR

09/05/11

(2120)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 09/05/11

(120)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST53

JS 09/05/12

(x120)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/12 JS

Job Completion



MF 09-05-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

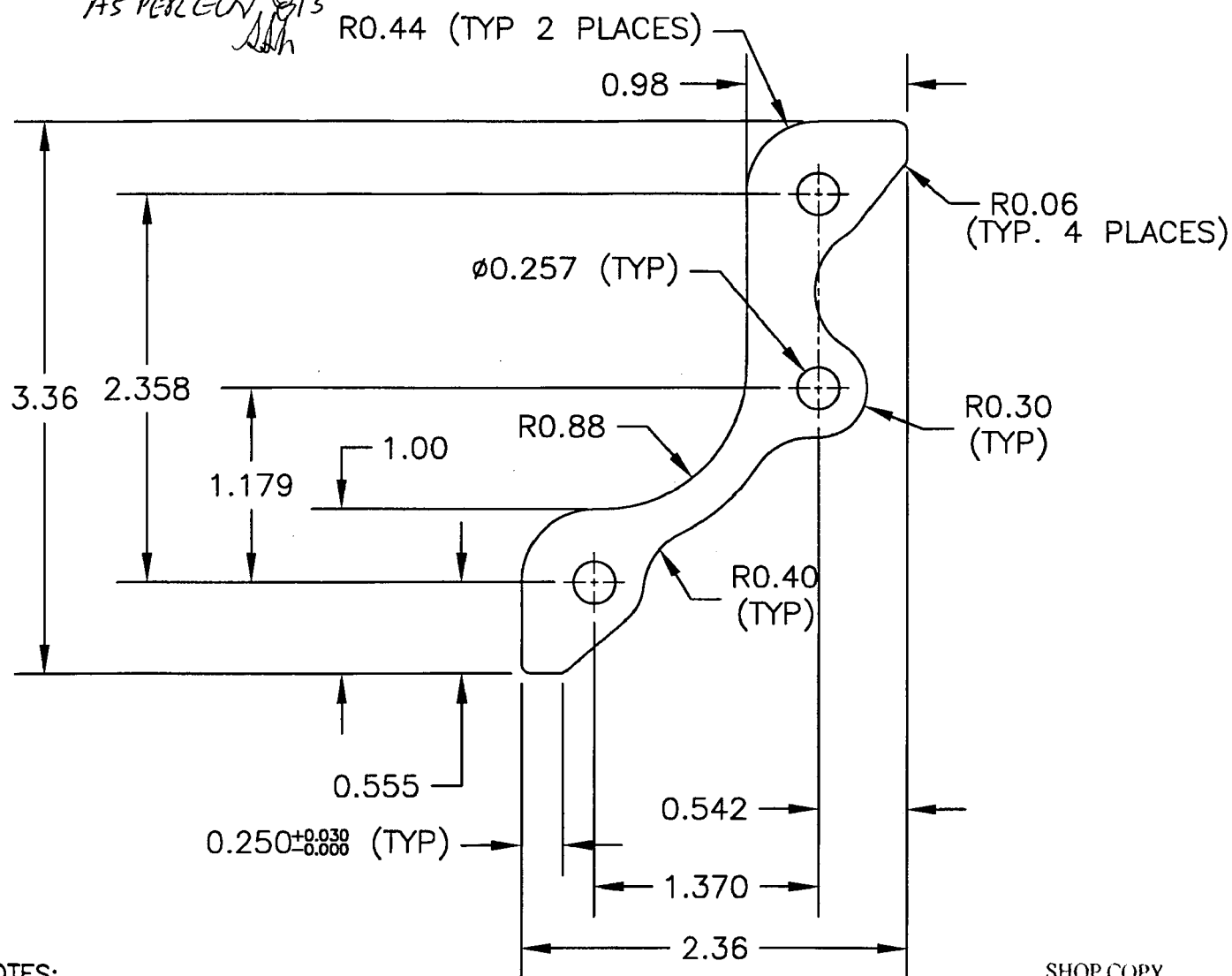
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>C.B.</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2877	REV. B SHEET 1 OF 1
DATE 06.05.17		TITLE SADDLE SPACER	SCALE 1:1
A	99.02.23	NEW ISSUE	
B	06.05.17	THICKNESS WAS 0.100", MAT CHANGE	

RELEASED
*06.06.21**AS PER ECN 813***NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.125" THICK
(REF DART SPEC M6061T6S.125)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.125" THICK
(REF DART SPEC M5052H32S.125)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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NO. *41292*

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